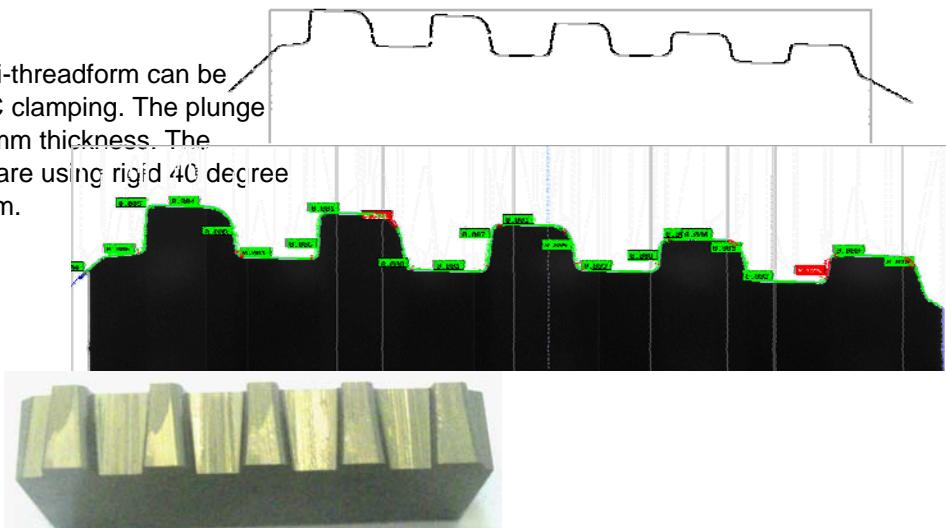
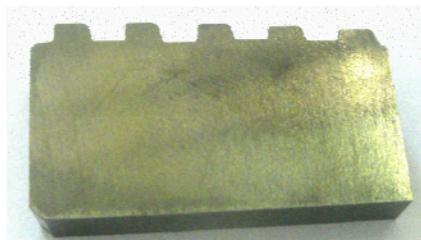


## Multithread insert 1-sided for tubes

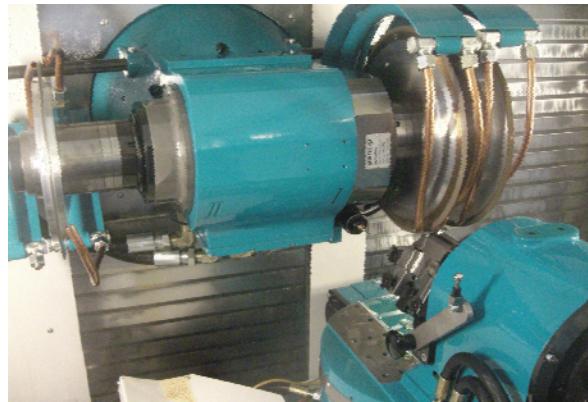
A08-010

The onesided Threadinsert with multi-threadform can be ground in one setup in standard RPC clamping. The plunge roughing operation uses a 1A1 of 2 mm thickness. The pregrinding and finishing operations are using rigid 40 degree V-shaped wheels of diameter 300 mm.



### 1. Cycletime for Production

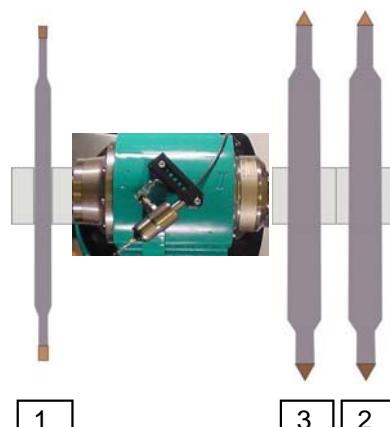
Workpiece: L 25.4 x 15.6 x 5.185 Material CARBIDE			
Operations	PlungRough	Pregrinding	Finishing
Feed [mm/Min]	20	25	20
Power [kW]	2	1	2
Cutting feed [m/s]	24	24	24
Used wheels	1	2	3
Grinding time [s]	304	124	142
Total cycle time	9 Min 48		



The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

1	14A1 Ø250 D64
2	14V1 Ø300 D76V40°
3	14V1 Ø300 D64V40°



### 3. Machine and Software Requirements

Machines: 5 axes CNC grinders : SIRIUS HPM

Coolant: Synthetic Oil, pressure 6 bar

Control: Fanuc 160i/310i

Software: Quinto 5

Accessories: STL6051

Responsible engineer: OP. 4.6.10

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